

Date: Tuesday, 15/07/2008 4:12:00 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 40515			Part Number	: D2572	
Estimate Number	: 10531			Drawing Number	: D2572 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 15/07/2008		S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 08/08/2008 Qty: 10 Um: Each
Previous Run	: 40085					
Written By	:					
Checked & Approved By	: JUL 08.7.16					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B34874	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 40515 Double check by: Y.A	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:00 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40515

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/15

(10)

5.0 QC8



SECOND CHECK



Comment: SECOND CHECK

8.15 08/08/19

(10)

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ 08/08/19

(10)

7.0 POWDER COATING



POWDER COATING



M108523

(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:45

11:45

OVEN TEMPERATURE: 322°

322°

FINISH TIME: 12:15

12:15

M.J 08/08/19

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ 08/08/19

(10)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS 08/08/20

(X10)

10.0 QC21



FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



-MF 08-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40515
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.439			
B	1.745	1.755		1.750	1.750	1.749"	1.750"		
C	3.495	3.505		3.499	3.500	3.501"	3.501"		
D	1.745	1.755		1.750	1.750	1.749"	1.750"		
E	7.990	8.010		8.000	8.000	8.005"	8.005"		
F	0.490	0.510		.499	.500	.504"	.504"		
G	0.257	0.262		.259	.259	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.500	.500	.500		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.565	.570	.569	.568		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.251		
S	0.115	0.135		.135	.134	.134	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.237	.239	.239		
W	0.115	0.135		.133	.132	.131"	.132"		
X	0.307	0.312		.307	.307	.307"	.307"		
Y	0.760	0.765		.761	.766	.760"	.760"		
Z	0.352	0.372		.367	.366	.366"	.368"		
AA	0.470	0.530		.500	.500	.500	R.500"		
AB	0.615	0.635		.626	.636	.630"	.630"		
AC	0.053	0.073		.063	.063	.063"	.063"		
AD	0.240	0.260		.241	.241	.243	.242		
AE	1.375	1.395		1.390	1.391	1.388	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.246	.249	.250		
AI	2.000	2.020		2.005	2.006	2.005	2.005		
AJ	0.023	0.043		.032	.033	.033"	.033		
Accept/Reject									

Measured by:	<i>gml</i>
Date:	08/08/13

Audited by:	<i>84</i>
Date:	08/08/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>28</i>	<i>gml</i>

DART AEROSPACE LTD	Work Order: 40515
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				X5	X6	X7	X8		
A	0.438	0.443		.439	.439"	.439	.439"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.501	3.501"	3.501	3.501"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.005"	8.005	8.005	8.005"		
F	0.490	0.510		.501"	.505"	.501"	.507"		
G	0.257	0.262		.258"	.258"	.258"	.258"		
H	0.375	0.380		.376"	.377"	.377"	.377"		
I	0.490	0.510		.502"	.502"	.502"	.503"		
J	1.174	1.184		1.182"	1.182"	1.182"	1.182"		
K	0.558	0.578		.570"	.566"	.568"	.569"		
L	1.174	1.184		1.180"	1.180"	1.181"	1.181"		
M	1.490	1.500		1.499"	1.499"	1.496"	1.496"		
N	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		.126"	.136"	.126"	.125"		
Q	0.115	0.135		.127"	.127"	.127"	.127"		
R	0.240	0.260		.252"	.251"	.251"	.250"		
S	0.115	0.135		.135"	.132"	.130"	.130"		
T	0.178	0.198		A.188"	A.188"	A.188"	A.188"		
U	2.940	2.980		2.959"	2.959"	2.959"	2.959"		
V	0.230	0.250		.243"	.244"	.244"	.244"		
W	0.115	0.135		.133"	.135"	.133"	.135"		
X	0.307	0.312		.307"	.309"	.310"	.309"		
Y	0.760	0.765		.760"	.760"	.760"	.760"		
Z	0.352	0.372		.370"	.370"	.372"	.372"		
AA	0.470	0.530		A.500"	A.500"	A.500"	A.500"		
AB	0.615	0.635		.631"	.631"	.630"	.630"		
AC	0.053	0.073		.063"	.063"	.063"	.063"		
AD	0.240	0.260		.240"	.252"	.250"	.252"		
AE	1.375	1.395		1.386"	1.386"	1.387"	1.385"		
AF	0.115	0.135		.135"	.135"	.135"	.135"		
AG	0.240	0.280		.280"	.280"	.280"	.280"		
AH	0.240	0.260		.249"	.253"	.251"	.253"		
AI	2.000	2.020		2.005"	2.005"	2.005"	2.005"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		

Accept/Reject

Measured by:	J.F.	Audited by:	88
Date:	08/08/15	Date:	08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	28/07/11

DART AEROSPACE LTD	Work Order:	40515
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

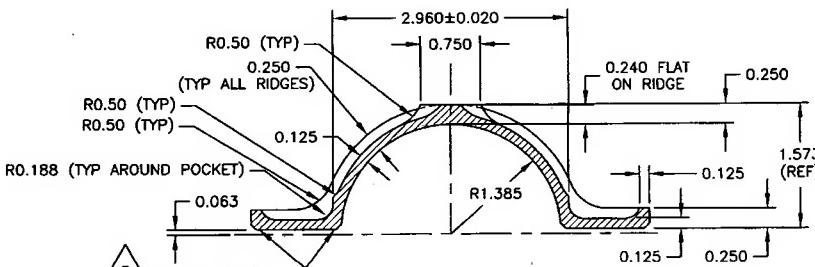
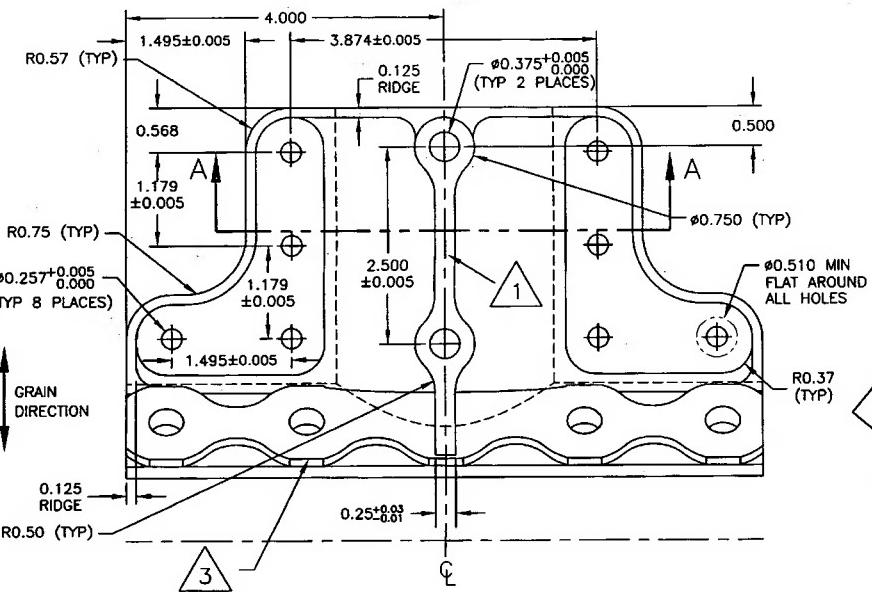
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				X9	Z10	3	4		
A	0.438	0.443		0.438"	0.439"	<del>0.439"</del>			
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.005"	8.005"				
F	0.490	0.510		0.505"	0.505"				
G	0.257	0.262		0.258"	0.258"				
H	0.375	0.380		0.372"	0.377"				
I	0.490	0.510		0.503"	0.503"				
J	1.174	1.184		1.182"	1.182"				
K	0.558	0.578		0.570"	0.570"				
L	1.174	1.184		1.181"	1.181"				
M	1.490	1.500		1.496"	1.496"				
N	2.495	2.505		2.502"	2.502"				
O	3.869	3.879		3.879"	3.874"				
P	0.115	0.135		0.126"	0.126"				
Q	0.115	0.135		0.127"	0.127"				
R	0.240	0.260		0.250"	0.250"				
S	0.115	0.135		0.135"	0.135"				
T	0.178	0.198		0.188"	0.188"				
U	2.940	2.980		2.959"	2.959"				
V	0.230	0.250		0.244"	0.244"				
W	0.115	0.135		0.135"	0.135"				
X	0.307	0.312		0.310"	0.310"				
Y	0.760	0.765		0.760"	0.760"				
Z	0.352	0.372		0.372"	0.372"				
AA	0.470	0.530		0.500"	0.500"				
AB	0.615	0.635		0.630"	0.630"				
AC	0.053	0.073		0.063"	0.063"				
AD	0.240	0.260		0.255"	0.255"				
AE	1.375	1.395		1.387"	1.387"				
AF	0.115	0.135		0.135"	0.135"				
AG	0.240	0.280		0.280"	0.280"				
AH	0.240	0.260		0.253"	0.253"				
AI	2.000	2.020		2.005"	2.005"				
AJ	0.023	0.043		0.023"	0.023"				

Accept/Reject

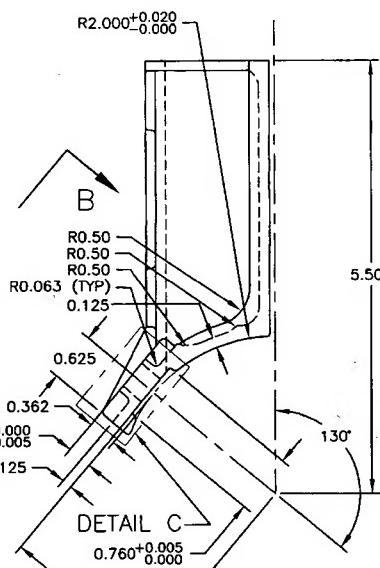
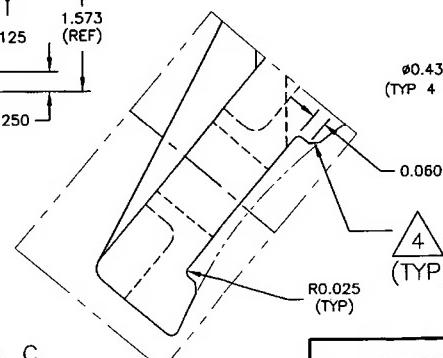
Measured by:	J.F.	Audited by:	85
Date:	08/08/15	Date:	08/08/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

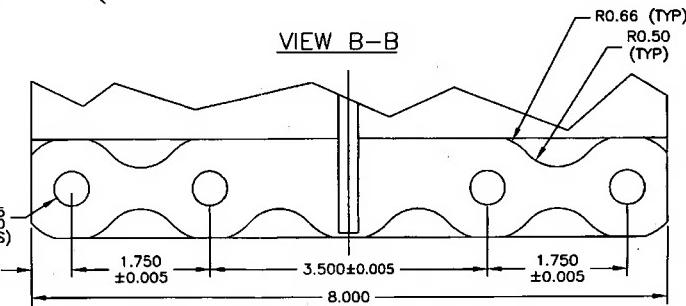


SECTION A-A

DETAIL C  
SCALE 2:1



## DETAILS



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

NETT TURNOVER 2,400,000 DOLLARS APPROXIMATELY

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OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROCRAFT LTD.

DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2572	REV. E	SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE		SCALE 2:3	

SHOP COPY  
RETURN TO  
ENGINEERING  
JNC CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40515